

Work Order ID 75330

75330

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Item ID: D2724-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Step Assembly
 Start Date: 20/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2724	Rev C								

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding
11.10.27 4 0

110 0.00
110 Large Fab
 Large Fab Memo 0.00
 Large Fab Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
 followed by Jig
 A/R AL ROD Batch: 114514
118735
 Grind end cap welds flush
11.10.27 4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	B61/10/28	
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				24	24		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

PTO

4x ✓ M-11/11/02
RH

W/O: 75330 1542		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2724-042 PAR #: _____ Fault Category: Large FAB NCR: Yes No DQA: in Date: 11/11/15
11-982 Resolution: use as is Disposition: use as is QA: N/C Closed: ck Date: 11/11/16

NCR: <u>11-982</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.10.27	110	AST lugs welded at 81.5° instead of 80° R.C. LOP. (Dry Clean + Sigs good)	<u>JB</u> after	Trial Sit step Step is okay	<u>JB</u> 11.10.27	<u>KE</u> 11.10.27	<u>JB</u> 09/11/17	<u>JB</u> 11.10.27

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	0		
160 *160* Large Fab Large Fab	Large Fab Memo Inspect for foreign object per QSI 024 Weld Remainig end cap as per Dwg D2724 A/R AL ROD Batch: <u>M114314</u> Grind end plate flush.	0.00 0.00				4	0		
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				x4 RH			
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4X ✓ MF 11/11/09 RH			
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 2:00 OVEN TEMPERATURE: 320°F FINISH TIME: 2:30	0.00 0.00				4X ✓ MF 11/11/09 RH			

M 118439

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	Wing Walk as per dwg QSI005 4.4 Batch <u>118988</u>	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing									
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00							
Quality Control									

4RH
 COUNTED & MEASURED
 4 BL 11-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 02/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo <i>PP175325</i>	0.00							<i>11/11/14</i>
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									<i>11/11/15</i>
QC	Memo	0.00							
Quality Control									

75330

11/11/14
(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734 *D2734* Step End Plate		Manufactured	No			110	Each	68.0000	1	4		<i>11.10.27</i>	
**													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				68					
				73196				8					
				73416				60					
D3458-1 *D3458-1* Step Mounting Plate		Manufactured	No			110	Each	9.0000	2	8		<i>11.10.27</i>	
**													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				8					
				71593				8					
				WA018				1					
				63075				1					
D3458-3 *D3458-3* Step Mounting Plate		Manufactured	No			110	Each	14.0000	2	8		<i>11.10.27</i>	
**													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				14					
				73327				14					
D2734 *D2734* Step End Plate		Manufactured	No			160	Each	68.0000	1	4		<i>11.10.27</i>	
**													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				68					
				73196				8					
				73416				60					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2622-120C

Manufactured No

100

Each

108.1200

1

4

D2622-120C

Step Extrusion

11.10.27

Location

Loc Qty

Loc Code

HALL

98.42

64409

6

68293

0.5

72131

91.92

WA

9.7

46910

2

66970

7.7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

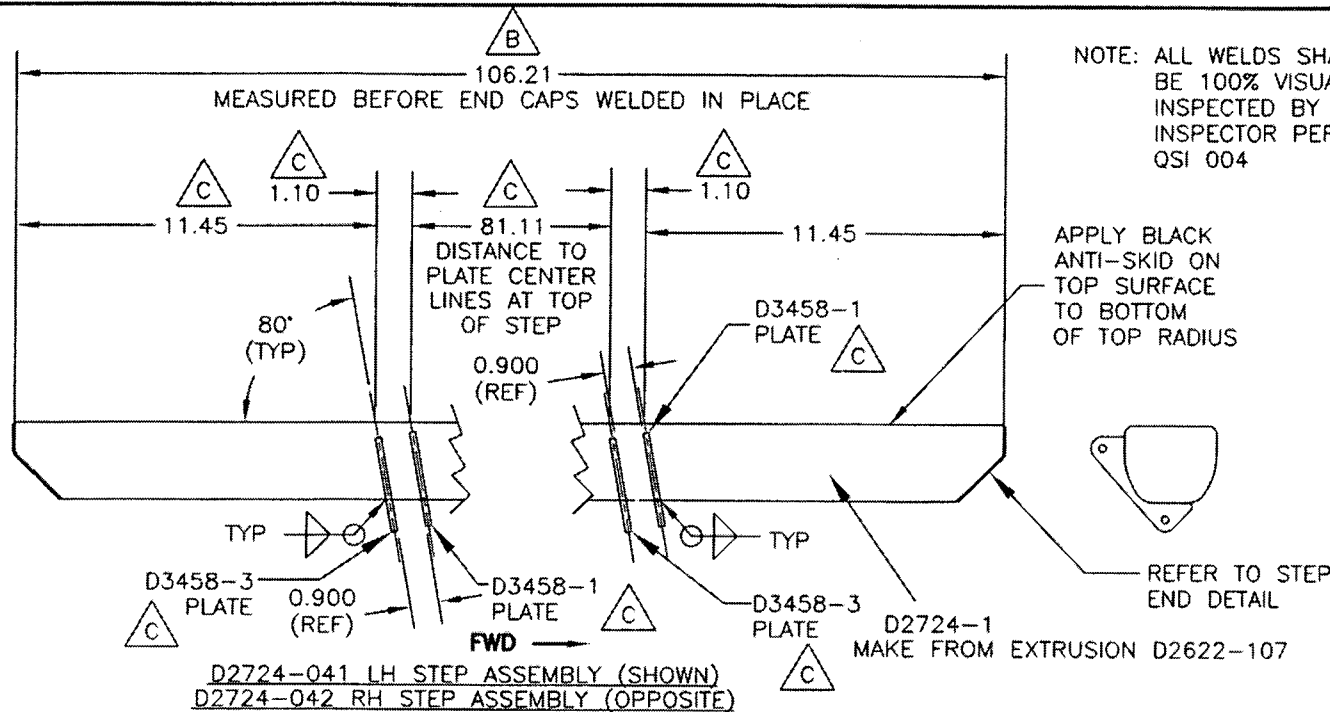
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DART

RELEASED
05-11-14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



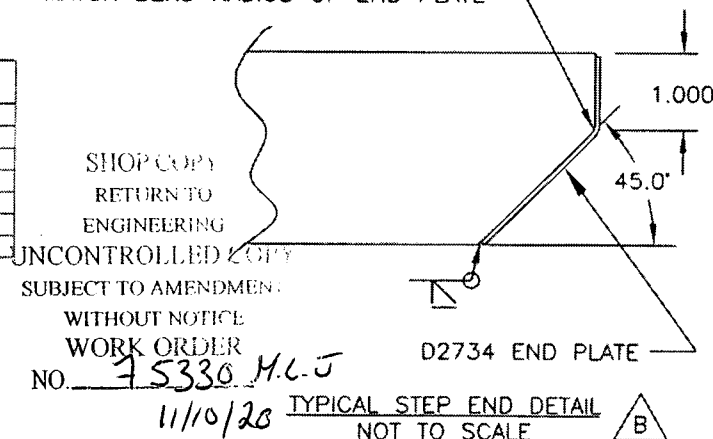
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75330 M.C.U

11/10/20

TYPICAL STEP END DETAIL
NOT TO SCALE

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